	er ID 60875 5, 2010 12:27:55 PM											Page
Revision ID:	D3536-15 Gasket		A	ccept					Setup	Start Stop		
	7/26/2010 Start Qt	y: 12.00 ty: 12.00			Cust Ite Custom	?	. !			,		
Approvals:	Process Plan:QC:	4	Date: 10 Z2C Date:	Tooling: SPC (Y/N):		Date:			Run	Start Stop		
equence ID/ Vork Center ID	Operation Description		6.	Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr			-		<u> </u>	-	_ ~;	Qij			Stamp
D3536	Rev A											
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LOW CNC Waterje	et	1-Cut as per Dv Deburr if necess	vg D3536 □Dwg Rev:_ sary	Prog Rev:_	□2-	1 1 1 1	±.				A	ð
	QC2- Inspec	et parts off mach	ine FAI/FAIB	0.00		,		HB.	10-7-	57		
Quality Control		Memo		0.00			:		,			
20 	QC8- Inspec	ot parts - second	check	0.00		1		(1)				
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W/O:			W	ORK ORDER CHANGE	ES				
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DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign	Verifica	tion	Approval	Approval
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Work	Order ID	60875
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Monday, July 26, 2010 12:27:55 PM



Page 2

Item ID:

D3536-15

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 8/3/2010

Gasket

7/26/2010

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Tool ID

Approvals:

Reference:

Process Plan:

Date:

Tooling:

. Date:

Start

_____ Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Run

Sequence ID/ **Work Center ID**

130



Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

0.00

Tool # Plan Code

Accept Qty

Reject Qty___

Reject Number

Insp. Stamp

Packaging

QC21- Final Inspection - Work Order Release

0.00

140 QC

Quality Control

Memo

Memo

0.00

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval** DATE **STEP PROCEDURE CHANGE** Bv **Q**ty **Date** Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section C Chief Eng QC Inspector Section A Date Chief Eng Chief Eng

Picklist Print

Monday, July 26, 2010 12:27:59 PM

Work Order ID: 60875

Parent Item: D3536-15

Parent Item Name: Gasket



Start Date: 7/26/2010

Start Qty: 12.00

Required Date: 8/3/2010

Page 1

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Oty	Qty Issued	Date Issued	Status
MNEO60S.063	18 118111 BB118 B1188 1111 1881	Purchased	No			100	sf	294.2233	0.9848	12.43958			
NEOPRENE SHEET 0 063	18 110111 08110 01101 (III 100)										10 115-	7-77	

NEOPRENE SHEET 0.063

Location Loc Qty Loc Code MAT 188.9702 114691 188.9702 MAT052 105.2531 114176 105.2531

114691

1810-7-07

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Cty Approval Chief Eng / Prod Mgr QC Inspector Approval QC Inspector

Part No:		_PAR #:	Fault Category:	NCR: Yes No	DQA:		Date:	
	Resolution:	<u></u>	Disposition:	QA: N/C Closed	:		Date:	

WORK ORDER NON-CONFORMANCE (NCR)

NCR:									
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DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Date		Sign & Date	Section C	Chief Eng	QC Inspector	
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DART AEROSPACE LTD	Work Order:	60875
Description: Gasket	Part Number:	D3536-15
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.18			T 1801	· · ·
35.65	+/-0.030	35.65	<u></u>	 	7	
33.65	+/-0.030	33.65	7		7	<u> </u>
30.15	+/-0.030	30.15	<i>y</i>		7	
24.90	+/-0.030	24.96	7		7	
19.65	+/-0.030	19.65	8		+	
14.40	+/-0.030	14,40	73		T	
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5.65	+/-0.030	5.65	⊌		7	
3.90	+/-0.030	3.90	8		V 1802	
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Date:	10-7-27	Date:	10/07/27	Date:	N/A

	Rev	Date	Change	Revised by	Approve⁄d
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DART

AEROSPACE PORT HADLOCK,

USA,

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REV.

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GASKET

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NEW ISSUE

23.15 17.65 - 0.90 - 5.65 1.89 DETAIL A 3.90 #0.19 (TYP 3 PLS)

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SHOPCOPYRETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WITHOUT NOTINE
WORK ORDER

D3536-11 GASKET

29.40 27.40 23.90 18.98 0.90 5.65 1.89 DETAIL A 3.90 14.00 €0.19 (TYP 4 PLS) 20.00 **D3536-13 GASKET**

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PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.083) 2) FINISH: NONE 3) PART IS SYMM PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES PURPOSE IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 7) SEE PAGE 6 FOR DETAILS AND SECTION 엻 COPIED

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval Approval QC Inspector DATE STEP dty PROCEDURE CHANGE By Date Chief Eng / Prod Mgr Part No: ______ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: _____ Resolution: _____ QA: N/C Closed: _ Date: ____

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39.15 07.02.12 35.65 33.65 30.15 -- 24.90 - 19.65 14.40 0.90 - 5.65 1.89 3.90 8.00 DETAIL A 4 PLS) 16.00 06.10.25 M 24.00 We 60875 D3536-15 GASKET 32.70 DRAWING NO. D3536 GASKET DART 21.80 0.90 DETAIL A 10.90 AEROSPACE PORT HADLOCK, 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) 1.89 2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED 2.00 - 6.00 8.00 #0.19 (TYP 4 PLS) ALL DIMENSIONS ARE IN INCHES
IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER 24.00 7) SEE PAGE 6 FOR DETAILS AND SECTION D3536-21 GASKET SHEET 2 OF 6 NC. SCALE 1:10

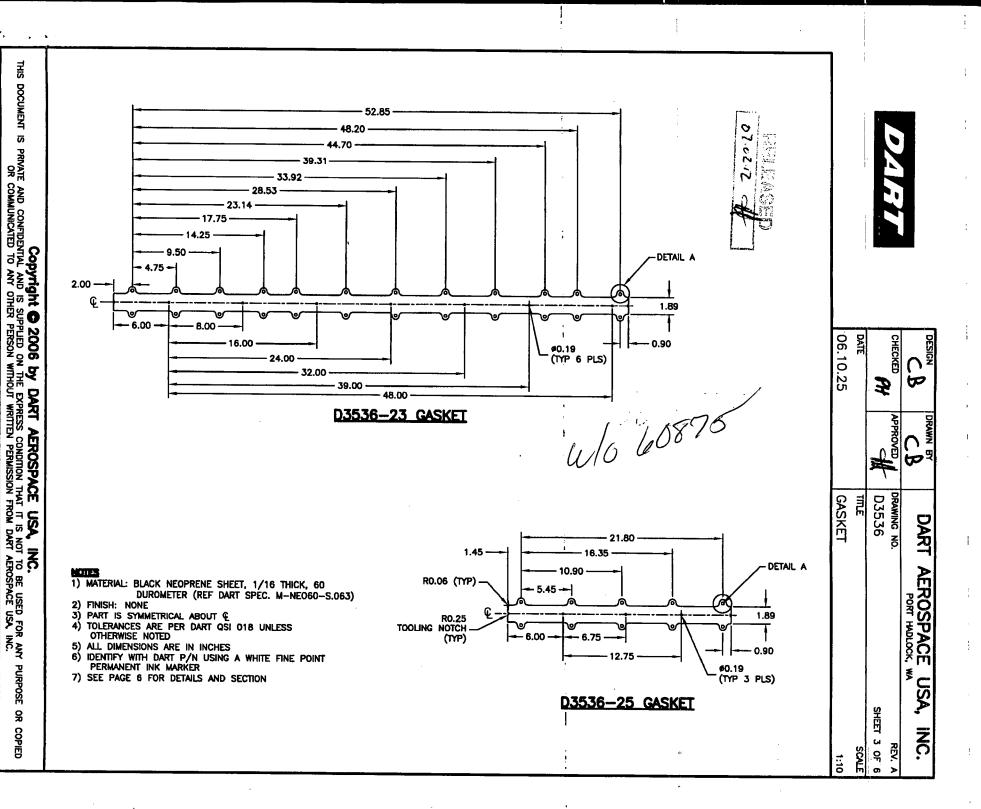
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Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval d**ty **STEP** PROCEDURE CHANGE DATE By Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B - Description of NC Verification **Approval Approval STEP** DATE Sign & **Action Description** Initial Section C Section A Chief Eng QC Inspector Date Chief Eng Chief Eng



Dart Aerospace Ltd

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DATE 06.10.25 CHECKED

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SHEET 4 OF 6

SCALE 1:10

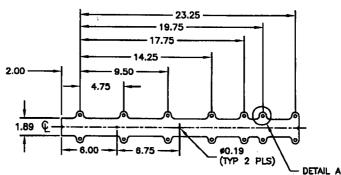
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DETAIL A

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D3536-33 GASKET w/o. 608.75



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D3536-35 GASKET

	22.50
	19.00
1.89 €	9.50 -6.00 DETAIL A -6.019 (TYP 3 PLS)

D3536-31 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
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 OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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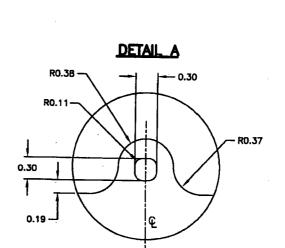
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D3536-41 GASKET

- NOTES

 1) MATERIAL: BLACK NEOPRENE SHEET, 1/18 THICK, 60
 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date C ty Chief Eng / Prod Mgr OC Inspector Approval OC Inspector Approval OC Inspector

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